

Work Order ID 68307

Monday, April 11, 2011 1:23:25 PM



Page 1

Item ID: D3186-4

Accept



Setup Start



Revision ID:

Item Name: Spacepod Door, RH

Stop



Start Date: 4/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: C2Date: 11/04/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3186	Rev E
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100 0.00

Small Fab

Small Fab 0.00

Small Fab Memo 1-Trim door to fit spacepod before drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

BT 11-08-29 x1

110 0.00

QC 0.00

Quality Control

MF 11-08-29 11

120 0.00

Identify as per dwg & Stock Location: Convo 103110 0.00

Packaging 0.00

Packaging Memo

BT 11-08-29 x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68307

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Monday, April 11, 2011 1:23:26 PM

Item ID: D3186-4

Accept



Setup Start



Revision ID:

Item Name: Spacepod Door, RH

Stop



Start Date: 4/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 11, 2011 1:23:22 PM

Page 1

Work Order ID: 68307



Parent Item: D3186-4



Parent Item Name: Spacepod Door, RH

Start Date: 4/11/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-11 EC

IPP rev.B revD 07.03.07 ec

IPP Rev:C

10-08-11 added trim door before drilling DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2M SPACEPOD DOOR RH		Manufactured	No		100	Each	0.0000	1	1			BT 11-08-29	

68311

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

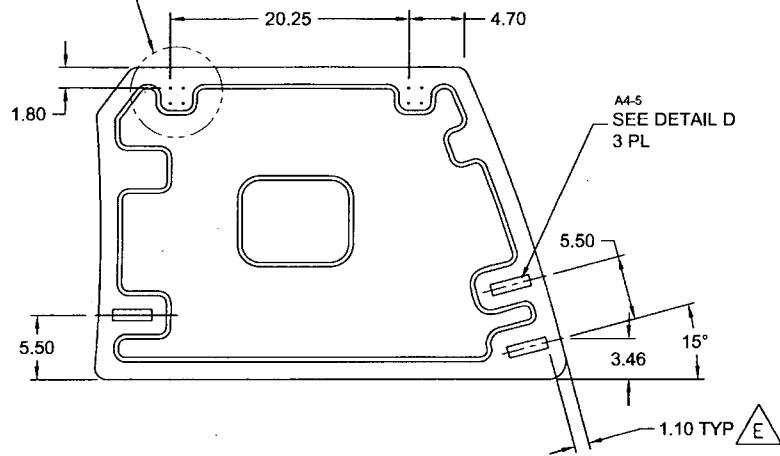
D

C

C

B

B

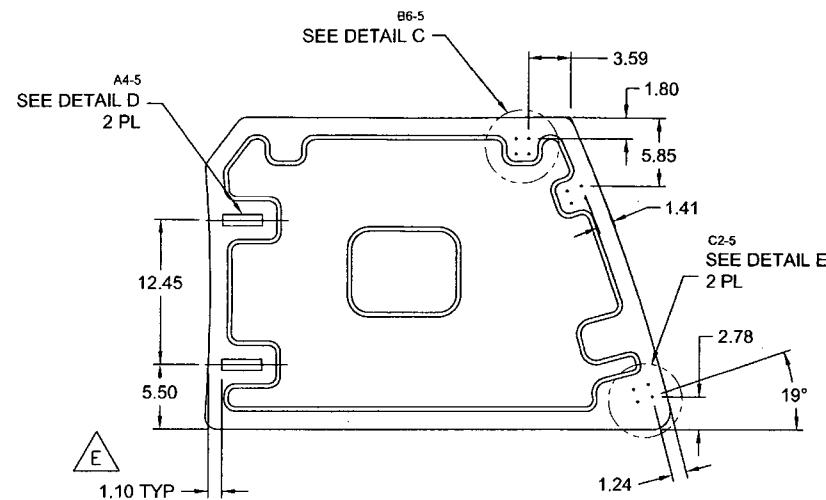


D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: N/A

CL 11/04/11

W 10:48 307



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M-2M-3I-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	IP	DRAWING NO.	REV. E
MFG. APPR.	NA	D3186	SHEET 1 OF 5
APPROVED	AP	TITLE	SCALE
DE APPR.	NA	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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D

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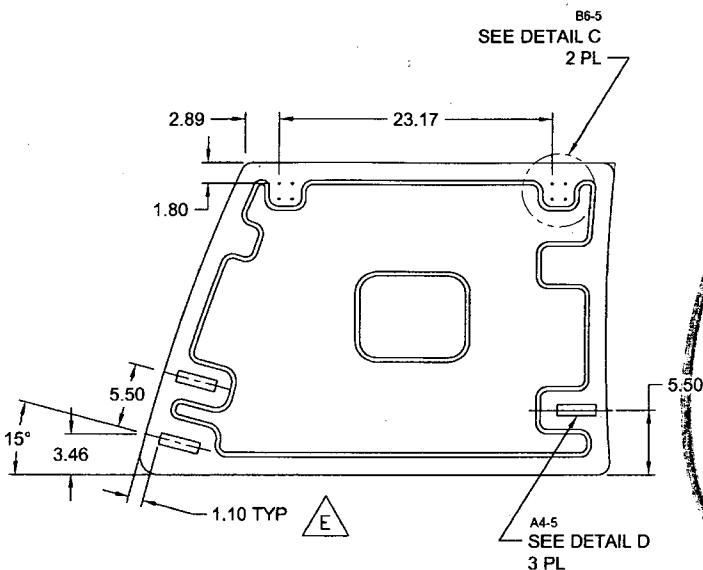
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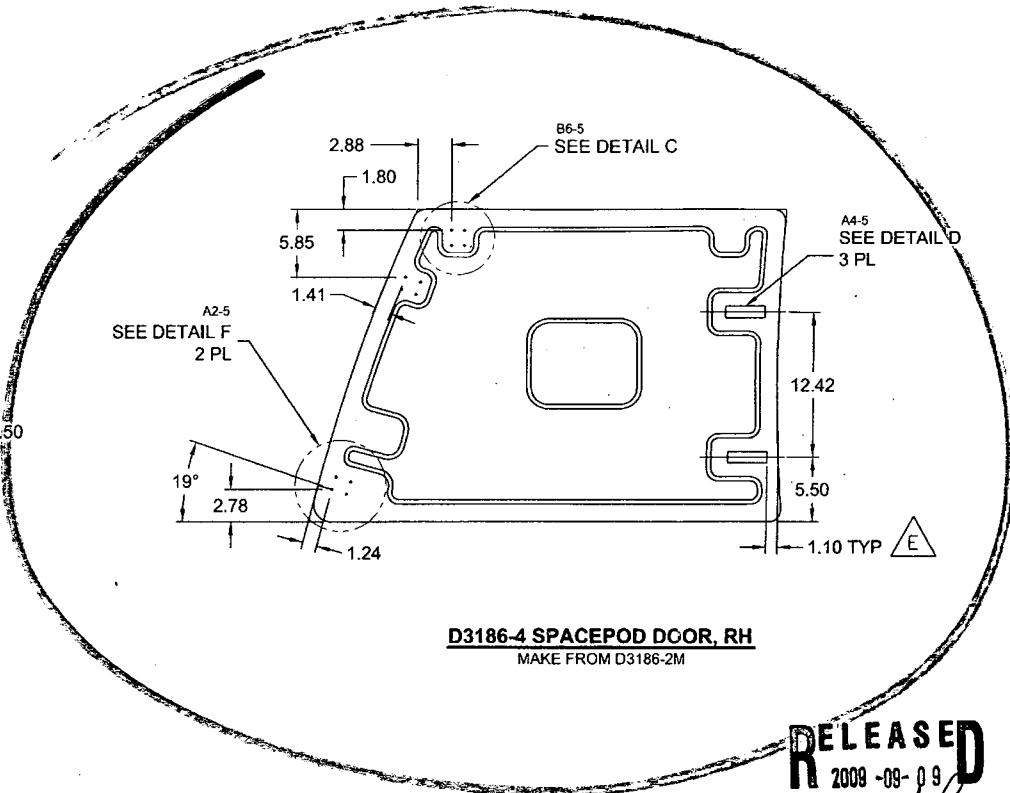
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D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

10.68307



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

RELEASED
2009-09-09

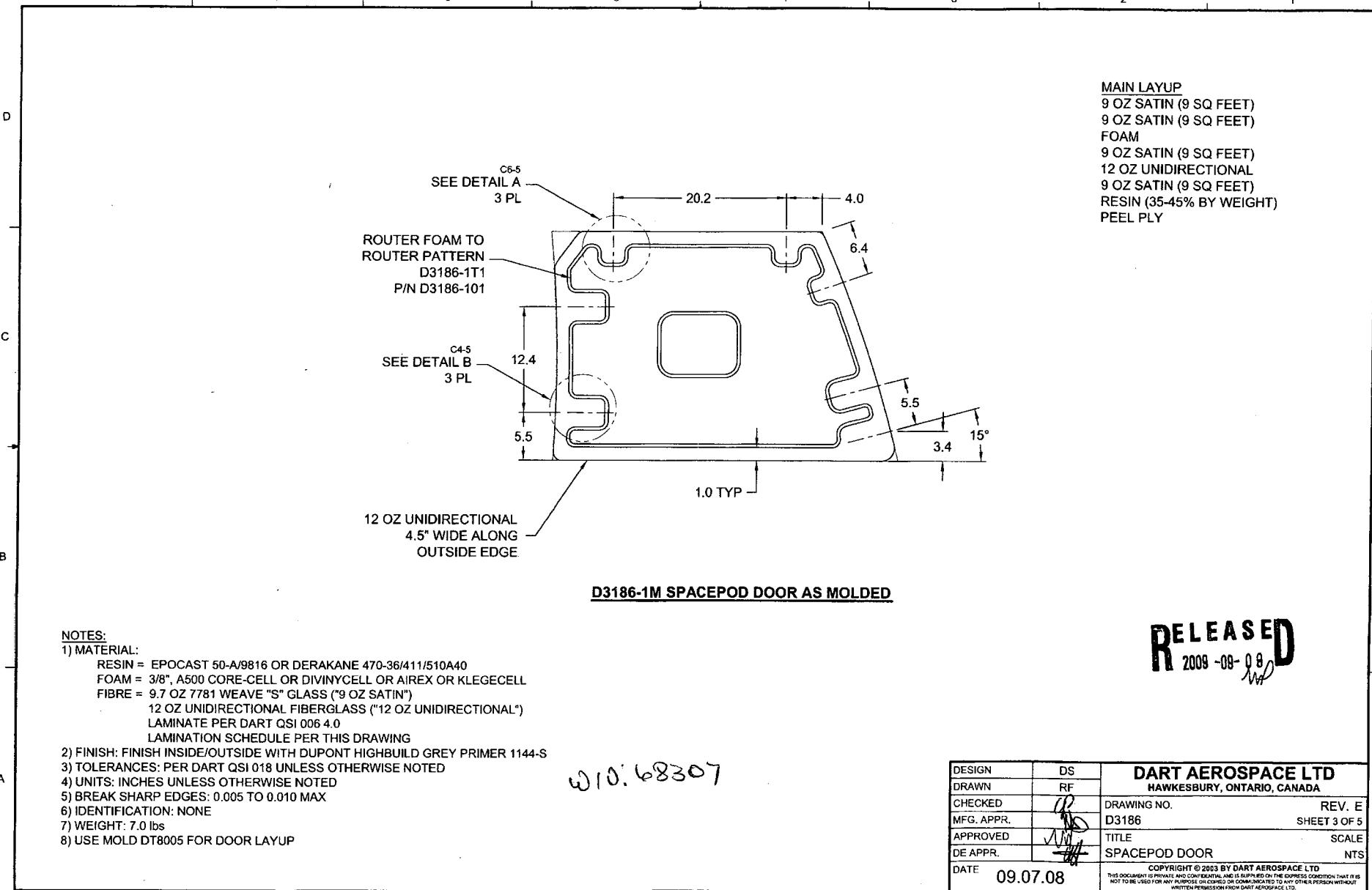
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>GR</i>	REV. E	
MFG. APPR.	<i>ND</i>	DRAWING NO.	
APPROVED	<i>MM</i>	D3186	SHEET 2 OF 5
DE APPR.	<i>MM</i>	TITLE	SCALE
DATE	09.07.08	SPACEPOD DOOR	NTS

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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

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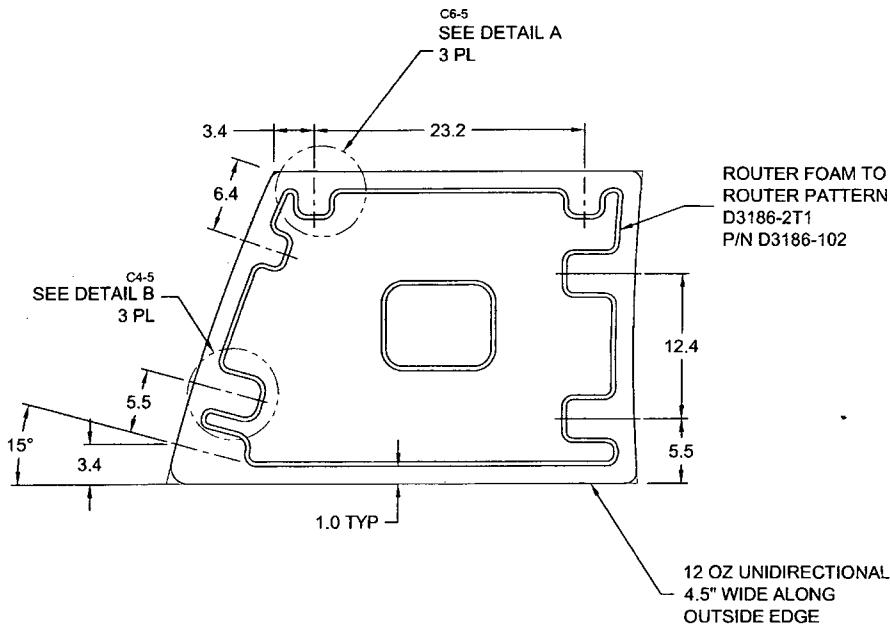
B

A

A

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



NOTES:

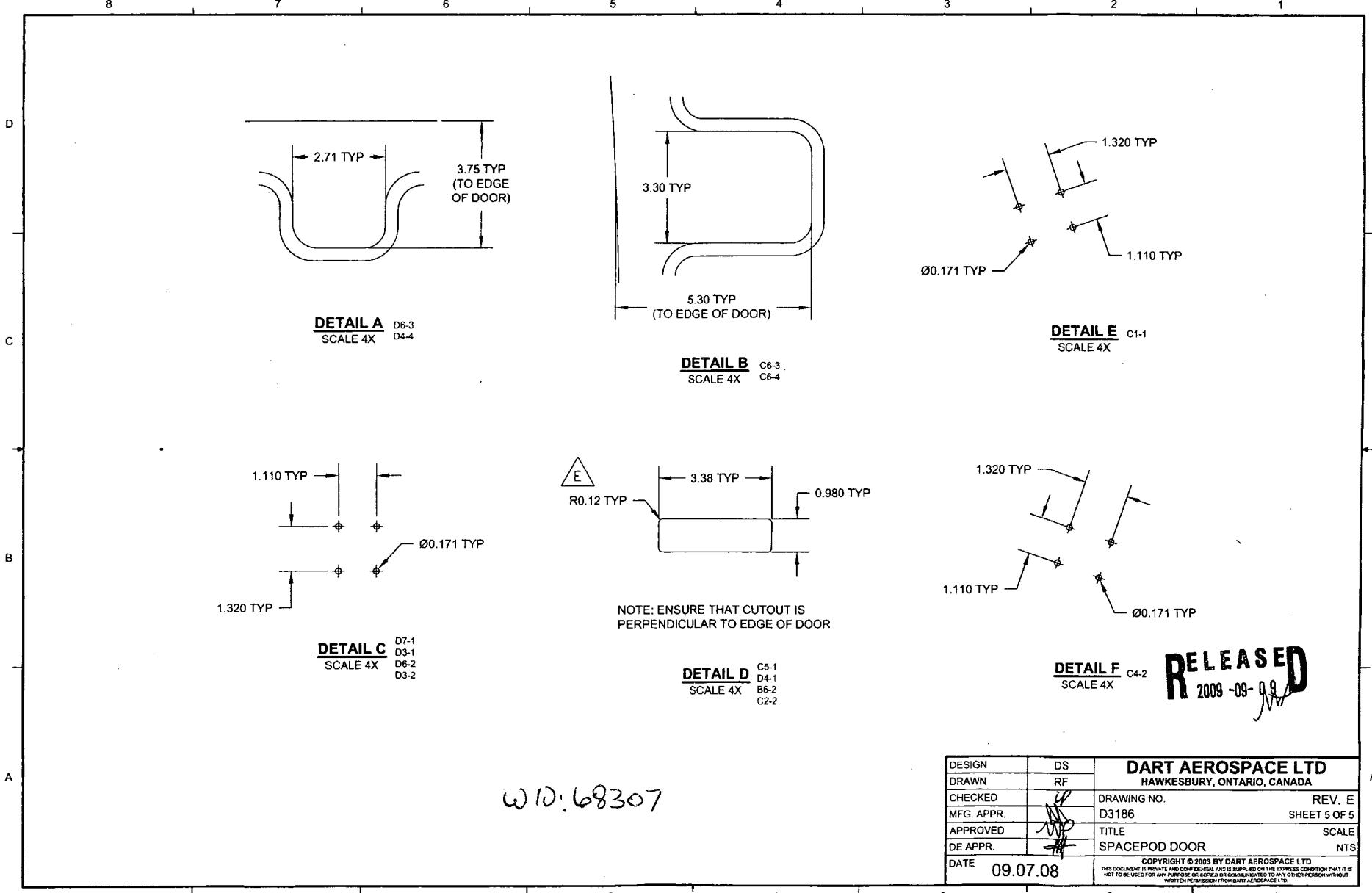
- 1) MATERIAL:
 - RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 - FOAM = 3/8", A500 CORE-CELL OR DIVINCELL OR AIREX OR KLEGECCELL
 - FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 - 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 - LAMINATE PER DART QSI 006 4.0
 - LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8006 FOR DOOR LAYUP

W10.68307

D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
 2008-09-09
MPD

DESIGN	DS	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>RF</i>	DRAWING NO.
MFG. APPR.	<i>MPD</i>	REV. E
APPROVED	<i>MPD</i>	D3186
DE APPR.	<i>MPD</i>	SHEET 4 OF 5
DATE	09.07.08	TITLE
		SPACEPOD DOOR
		SCALE
		NTS
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	REV. E	
MFG. APPR.	RF	DRAWING NO.	
		D3186	SHEET 5 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD DOOR	NTS
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